

Work Order ID 56941-2

Monday, March 15, 2010 11:41:16 AM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 3/15/2010 Start Qty: 12.00

Required Date: 3/19/2010 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan: mf

Date: 10-3-15

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject

Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100



Large Fab

Large Fab

0.00

0.00

Memo

- 1- Cut tube 54" ✓
- 2- Bend tube with manuel pipe bender as per dwg d3916-1 ✓
- 3- Drill and chamfer holes as per dwg D3916-1 ✓
- 4- Trim access tube material to finish size as per dwg D3916
- 5- weld bushing as per dwg D3916
- 6- grind welds flush

9

CP 10.03.29

X12

CP 10.03.29

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 10 13 12

0.00

Memo

+9

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Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

10.03.29

130



Packaging

Packaging

Identify as per dwg & Stock Location: Boxed

0.00

Memo

0.00

9 PD 10.03.30

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/31

10-3-31
9

Print

Monday, March 15, 2010 11:41:16 AM

Page 1

Work Order ID: 56941

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Date: 3/15/2010

Required Date: 3/19/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	48.0000	84.0000			



Bushing

lpl 10.03.23

M304TS0.750W.049

Purchased

No



304 SQ Tube .75x.75x.049W

Warehouse

Location

Main Warehouse

WA

Loc Qty

48

53442

2

54072

9

55789

1

56143

36

100

f

Loc Code

B56944 → (50) lpl

170.5455

56.8421



(14) lpl

[Signature]

Warehouse

Location

Main Warehouse

MAT

Loc Qty

170.5455158

106604

2.4123

107460

28.2726

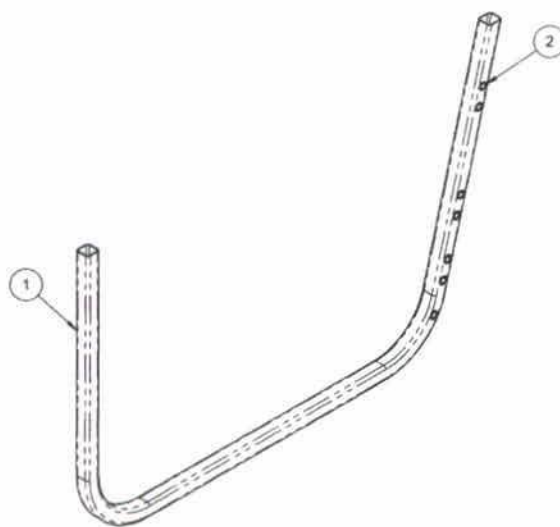
113763

139.860616

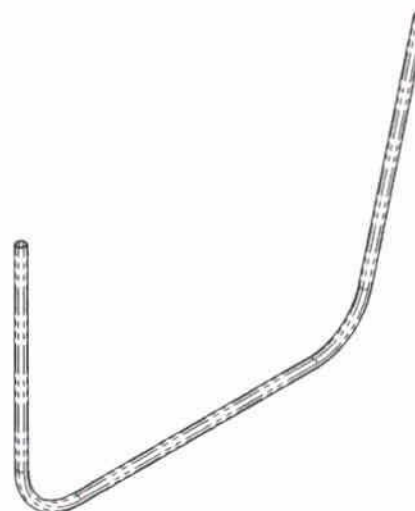
Loc Code

10 10.03.22

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY

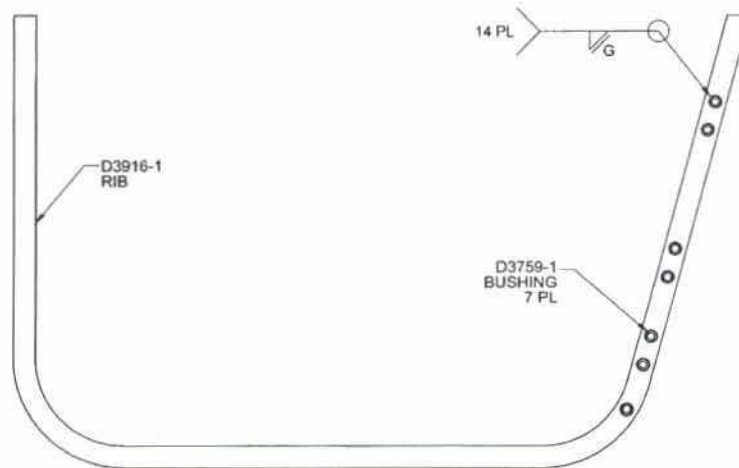


D3916-5 LIGHT RIB

RELEASED
2010-03-12
WP

56941

A	NEW ISSUE	JPH	10.03.04
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR REPRODUCED IN ANY FORM WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3916-041 RIB ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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2010-03-12
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56941

